

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007997**Date Inspected:** 08-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress.

BAY#11

FCAW welding process of weld joint 58 located on PCMK WSD1-TL6J/L. Welder is identified as 068493 ZPMC QC is identified as Zhong Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

SMAW welding process of weld joint 54A located on PCMK ESD1-FBSA4-2A/C. Welder is identified as 040690 ZPMC QC is identified as Tao Lu Hai. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

BAY#10

FCAW welding process of weld joint 82 located on PCMK NSTL3-3C/K. Welder is identified as 201825 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

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FCAW welding process of weld joint 75 located on PCMK NSTL3-3F/K. Welder is identified as 052075 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 150 located on PCMK NSTL3-3F/K. Welder is identified as 057266 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

TRIAL ASSEMBLY YARD

FCAW welding process of weld joint 026 located on PCMK OBW2C. Welder is identified as 048801 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2114.

BAY#1

FCAW welding process of weld joint 142 located on PCMK CB201G-013. Welder is identified as 059450 ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

BAY#3

FCAW welding process of weld joint 95 located on PCMK CSD6-PP89. Welder is identified as 204338 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

TRIAL ASSEMBLY YARD

VISUAL INSPECTION

This QA noted the following Observation during the random visual inspection in Trial assembly yard.

This QA Inspector observed ZPMC performing the weld repair on transverse splice between segment 1AE and 1BE.

This QA Inspector observed ZPMC the performing gouging on the weld joint of 37X plate at PP23 in segment 3BE north side.

This QA Inspector observed Counter weight 12 fit up in progress.

This QA Inspector observed ZPMC performing gouging on the weld joint between Drip plate to Deck panel on west line at near the PP 11 and 10.

This QA Inspector observed ZPMC the performing gouging on the weld joint of 37X plate at PP25 in segment 4AE north side.

This QA Inspector observed ZPMC performing bolt tensioning on 'U' rib bolt at PP22 in segment 3AE-3BE

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Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
